

Work Order ID 81862

81862

Page 1

Tuesday, March 20, 2012 9:27:41 AM

Item ID: D350-591-312

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Heli-Access-Step, Long RH

Stop

NS2

Start Date: 3/20/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 3/27/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan:

Date: 12/23/20

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D3272	Rev B								

100

100

DOCUMENT CONTROL

DC

Document Control

Memo

Photocopy bluefile and type labels as per PPP D350-591-312 CHG002
NON EUROCOPTER

S. Schulz

12/23/2012-12-4-17

(4)

110

110

Large Fab

0.00

12/04/02 4/05

Large Fab

Memo

1-Bevel end for welding FWD ONLY

0.00

Large Fab

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg

D3272

A/R Aluminum Rod

119135
100169

3-Grind End Plate flush

→ Ae 12.04.05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 81862

81862

Page 2

Tuesday, March 20, 2012 9:27:41 AM

Item ID: D350-591-312

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Heli-Access-Step, Long RH

Stop

NS2

Start Date: 3/20/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 3/27/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00

4

0

AE 12/09/05

120

QC

Quality Control

130

QC5- Inspect part completeness to step on W/O

0.00

8/26/05

4

4

130

QC

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

0.00

Ac 12.04.05

(X4)

4

140

HandFinish

Hand Finishing

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 81862

81862

Page 3

Tuesday, March 20, 2012 9:27:41 AM

Item ID: D350-591-312

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Heli-Access-Step, Long RH

Stop

NS2

Start Date: 3/20/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 3/27/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC3- Inspect Part Finish

0.00

150

QC

Quality Control

(X4)

12.04.11

180

Large Fab

0.00

180

Large Fab

Memo

0.00

Large Fab

1-Assemble Leg Assembly as per Dwg D3272.

2-Leave one rivet out until welding is complete.

3-Bevel Aft end for welding

4-Inspect for foreign object as per QSI 024

5-Weld Aft End Plate as per QSI 004 & Dwg D3272
A/R Aluminum Rod 119185

6-Grind End Plate flush

7-Install last rivet as per Dwg.

(X4)

12.04.11
Ac

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 81862

81862

Page 4

Tuesday, March 20, 2012 9:27:41 AM

Item ID: D350-591-312

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Heli-Access-Step, Long RH

Stop

NS2

Start Date: 3/20/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 3/27/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC10- Inspect visual per QSI004- ground welds

0.00

0.00 *S7kew13*

190

QC

Memo

Quality Control

200

QC5- Inspect part completeness to step on W/O

0.00

0.00 *S7kew13*

200

QC

Memo

Quality Control

210

Chemical Conversion Coat per QSI005 4.1

0.00

0.00

210

HandFinish

Memo

Hand Finishing

M/F
12/04/13

4x &
RH

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 81862

81862

Page 5

Tuesday, March 20, 2012 9:27:41 AM

Item ID: D350-591-312

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Heli-Access-Step, Long RH

Stop

NS2

Start Date: 3/20/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 3/27/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

220

220

Powdercoat

Powder Coating

W (20222)

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

4X Ø

m/f
12/04/14

Memo

7:45

0.00

START TIME:

320⁰¹

OVEN TEMPERATURE:

FINISH TIME: 8:15

230

230

HandFinish

Hand Finishing

Wing Walk as per dwg QSI005 4.4 Batch 120902

0.00

Memo

0.00

4 Ø

RH

28 12/04/17

240

240

QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

S. Shulig

4
BV

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approvál QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 81862

81862

Page 6

Tuesday, March 20, 2012 9:27:41 AM

Item ID: D350-591-312

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Heli-Access-Step, Long RH

Stop

NS2

Start Date: 3/20/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 3/27/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

250

Pick Kit

0.00

4

12/04/18 JB

250

Packaging

Memo

0.00

Packaging

260

QC4- 100% Inspect kits for completeness

0.00

S.7kwl9

AM
RH

260

QC

Memo

0.00

Quality Control

270

Packaging

0.00

270

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD350-591-312

Location:

FG022

4X

SP
12-04-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

Tuesday, March 20, 2012 9:27:45 AM

Work Order ID: 81862

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

81862
D350-591-312

Start Date: 3/20/2012

Required Date: 3/27/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A04.03.22New issue KJ/RF

IPP Rev:B 07-06-09 Added D3572-1 JLM

IPP Rev:C 08-04-02 ECN1163 DD verified by:EC

IPP Rev:D 08-04-08 ECN1164 DD verified by:EC

IPP Rev:D

fixe route seq in bom DD 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

DSI 9410-011		Manufactured	No				Each	0.0000	**	4			
--------------	--	--------------	----	--	--	--	------	--------	----	---	--	--	--

DSI 9410-011													
----------------	--	--	--	--	--	--	--	--	--	--	--	--	--

Step Modification													
-------------------	--	--	--	--	--	--	--	--	--	--	--	--	--

D3272-1		Manufactured	No		110		Each	20.0000	1	4			
---------	--	--------------	----	--	-----	--	------	---------	---	---	--	--	--

D3272-1													
-----------	--	--	--	--	--	--	--	--	--	--	--	--	--

Step													
------	--	--	--	--	--	--	--	--	--	--	--	--	--

Location

ST	382019	-10	Loc Code
WA		30	
	80179	10	
	80180	10	

D3067-1		Manufactured	No		110		Each	158.0000	1	4			
---------	--	--------------	----	--	-----	--	------	----------	---	---	--	--	--

D3067-1													
-----------	--	--	--	--	--	--	--	--	--	--	--	--	--

End Plate													
-----------	--	--	--	--	--	--	--	--	--	--	--	--	--

Location

WA	78608	132	Loc Code
	80881	72	
		60	
WA016		26	
	67582	2	
	68214	1	
	79607	23	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC. Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 2

Tuesday, March 20, 2012 9:27:45 AM

Work Order ID: 81862

81862

Parent Item: D350-591-312

D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 3/20/2012

Required Date: 3/27/2012

Start Qty: 4.00

Required Qty: 4.00

D3219-1

Manufactured No

110

Each

60.0000

2

8

**

*112-04-02****D3219-1***

Plate

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA016 <i>382059</i>	60	<i>8</i>
73410	12	_____
77674	6	_____
78763	42	_____

D3066-1

Manufactured No

180

Each

46.0000

**

*B81968 X8 Ae 12-04-11****D3066-1***

Spacer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA	46	_____
78605	46	_____

MS20600-AD4W4

Purchased No

180

Each

2,518.000

**

*M121390 64 Ae 12-04-11****MS20600-AD4W4***

Rivets

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST321	2513	_____
116188	59	_____
117364	253	_____
117601	200	_____
117885	195	_____
118840	1089	_____
119860	30	_____
119883	155	_____
120308	72	_____
120769	260	_____
121011	200	_____
WA018	5	_____
116712	5	_____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 3

Tuesday, March 20, 2012 9:27:45 AM

Work Order ID: 81862

81862
D350-591-312

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 3/20/2012

Required Date: 3/27/2012

Start Qty: 4.00

Required Qty: 4.00

D3065-041

Manufactured No

180 Each

34.0000

1 4

**

B 78798

(X3)

Ac 12.04.11

D3065-041

Step Leg Assembly Hi

Location	Loc Qty	Loc Code
WA	34	
66149	0	
78799	33	
79336	1	

D3067-1

Manufactured No

180 Each

158.0000

1 4

**

12.04.12

D3067-1

End Plate

Location	Loc Qty	Loc Code
WA	132	
78608	72	
80881	60	
WA016	26	
67582	2	
68214	1	
79607	23	

AN3-35A

Purchased No

250 Each

247.0000

2 8

**

JB

12/04/18

S_x
AN3-35A
Bolt

Location	Loc Qty	Loc Code
ST353	247	
120187	47	
120644	50	
120717	50	
121068	100	

121068

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 4

Tuesday, March 20, 2012 9:27:45 AM

Work Order ID: 81862

81862

Parent Item: D350-591-312

D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 3/20/2012

Required Date: 3/27/2012

Start Qty: 4.00

Required Qty: 4.00

D3235-1

Manufactured

No

250

Each

145.0000

2

8

**

✓

JB

[Signature]

D3235-1

Mounting Lug

D3278-041

Manufactured

No

Location

Loc Qty

Loc Code

ST

145

78787

145

250

Each

1.0000

1

78787

4 ✓

78795

JB

[Signature]

D3278-041

Support Assembly

AN960JD416

NAS1149D0463J

Purchased

No

Location

Loc Qty

Loc Code

ST481

1

78794

1

250

Each

14.0000

16

64 ✓

121255

JB

[Signature]

AN960.ID416

Washer

AN960JD516

NAS1149D0563J

Purchased

No

Location

Loc Qty

Loc Code

ST351

14

116289

14

250

Each

0.0000

4

16 ✓

118614

JB

[Signature]

AN960.ID516

Washer

AN5-36A

Purchased

No

Location

Loc Qty

Loc Code

ST340

162

120187

112

120731

50

120187

JB

[Signature]

AN5-36A

Bolt

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 5

Tuesday, March 20, 2012 9:27:45 AM

Work Order ID: 81862

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

81862
D350-591-312

Start Date: 3/20/2012

Required Date: 3/27/2012

Start Qty: 4.00

Required Qty: 4.00

D2618 Manufactured No 250 Each 304.0000 12 8 **

D2618

S-4
Bushing

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST012	304	
76130	2	
78537	102	78537
80474	200	

D2230-3

Manufactured No 250 Each 179.0000 4 f 16 **

D2230-3

Lug

S-4

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST480	179	
53881	4	
70973	1	
80009	174	

D2856-400

Manufactured No 250 f 197.2345 1.2 4.8 **

D2856-400

Abrasion Strip

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST409	197.2345	
63735	0.6696	
68076	0.3149	
71164	8.46	
79551	187.79	79551

→ measured size 1/16"
cut (2) D2856-400-720 as per dwg

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 6

Tuesday, March 20, 2012 9:27:45 AM

Work Order ID: 81862

81862
D350-591-312

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 3/20/2012

Required Date: 3/27/2012

Start Qty: 4.00

Required Qty: 4.00

MS21042L3

Purchased

No

250

Each

3,027.000

2

8

**

MS210421 3

Nut

ed

Location	Loc Qty	Loc Code
ST300	3027	
117441	16	
117885	32	
118451	5	
118927	3	
119017	2798	119017
119075	173	

AN4-13A

Purchased

No

250

Each

1,357.000

8

32

**

AN4-13A

Bolt

Location	Loc Qty	Loc Code
ST357	1357	
119449	59	
120187	398	
120422	500	120422
120770	400	

MS21042L5

Purchased

No

250

Each

1,588.000

2

8

**

MS210421 5

Nut

Location	Loc Qty	Loc Code
ST300	1588	
116105	5	
116548	43	
117611	42	
119109	1498	119109

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 7

Tuesday, March 20, 2012 9:27:45 AM

Work Order ID: 81862

81862

Parent Item: D350-591-312

D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 3/20/2012

Required Date: 3/27/2012

Start Qty: 4.00

Required Qty: 4.00

MS21042L4

Purchased

No

250

Each

5,307.000

8

32

✓

**

JB

12/04/18

S Nut
MS21042L4

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST300	5307	
117441	51	
117601	21	
118451	133	
119017	200	
119075	2902	119075
121011	2000	

AN960JD10

NAS1149D0363J Purchased

No

250

Each

0.0000

4

16

✓

**

121243 JB

12/04/18

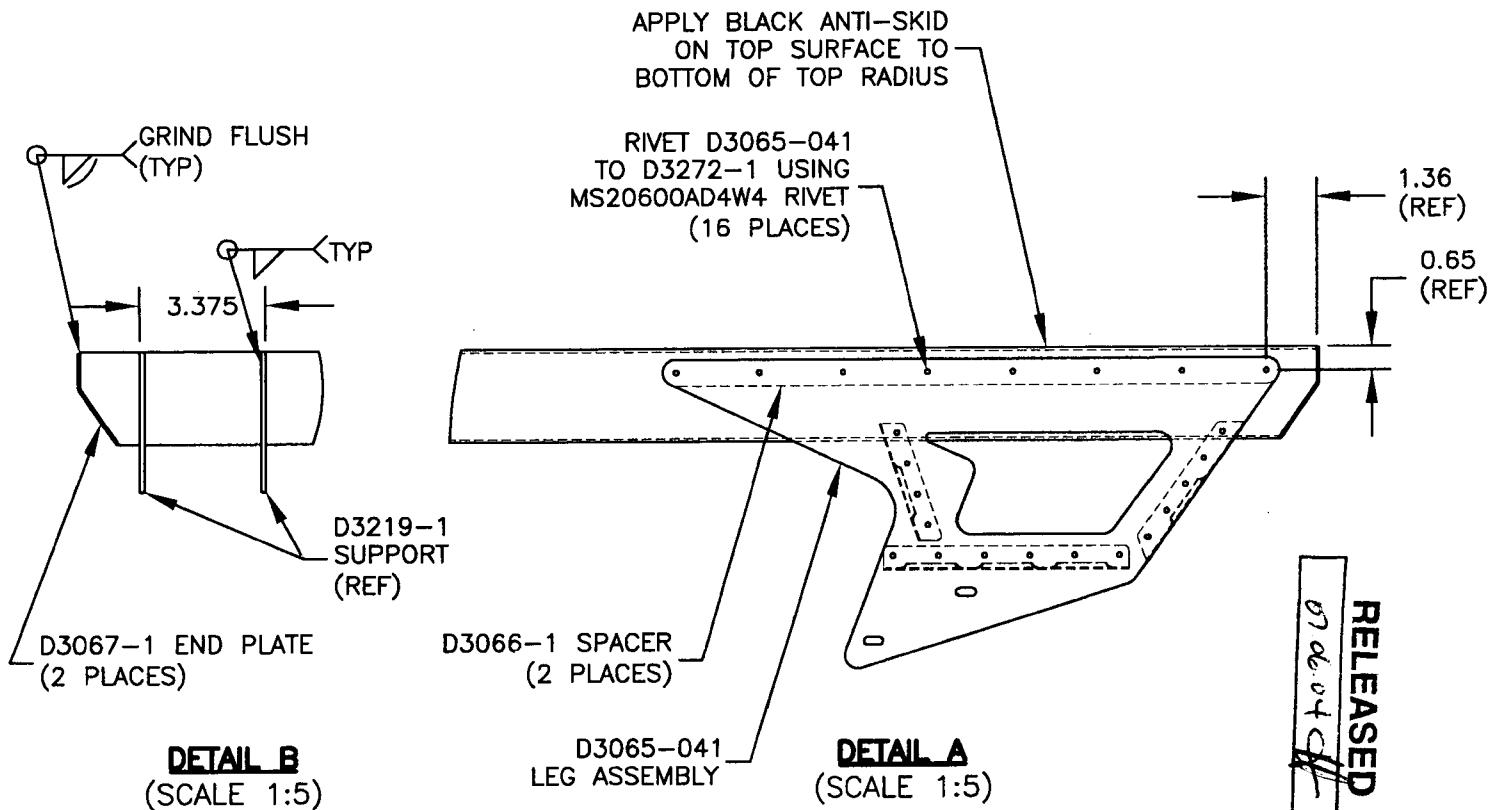
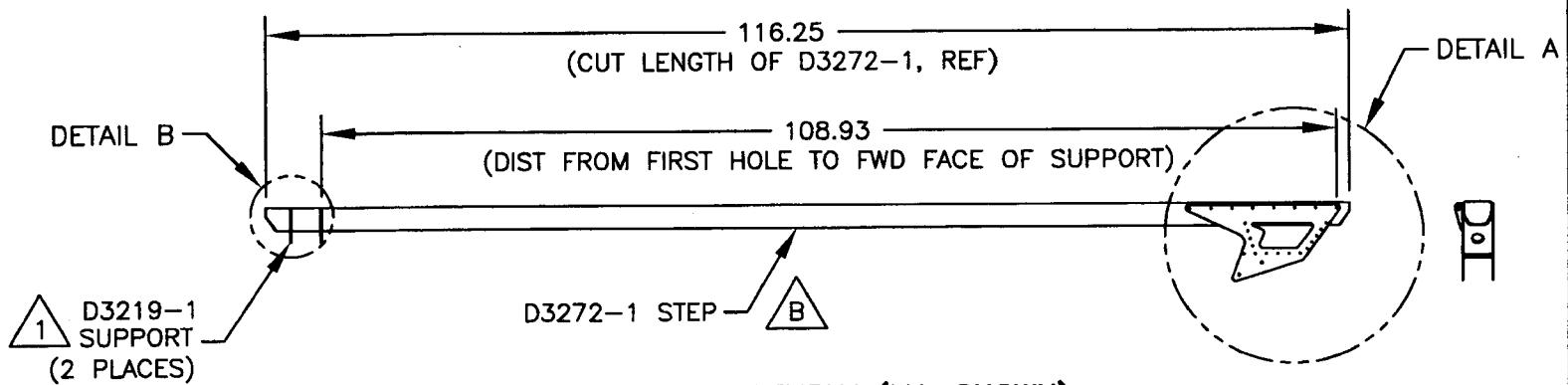
S Washer
AN960JD10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	90	DRAWN BY	<i>LB</i>	DART AEROSPACE LTD
CHECKED	<i>CE</i>	APPROVED	<i>CH</i>	HAWKESBURY, ONTARIO, CANADA
DATE	07.05.18	DRAWING NO.	D3272	REV. B
		TITLE	STEP ASSEMBLY, LH LONG	SHEET 2 OF 3
				1:20 SCALE

DART

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

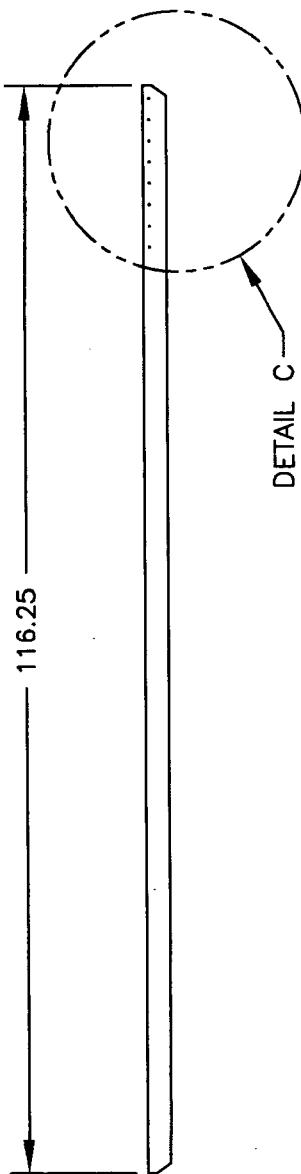
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

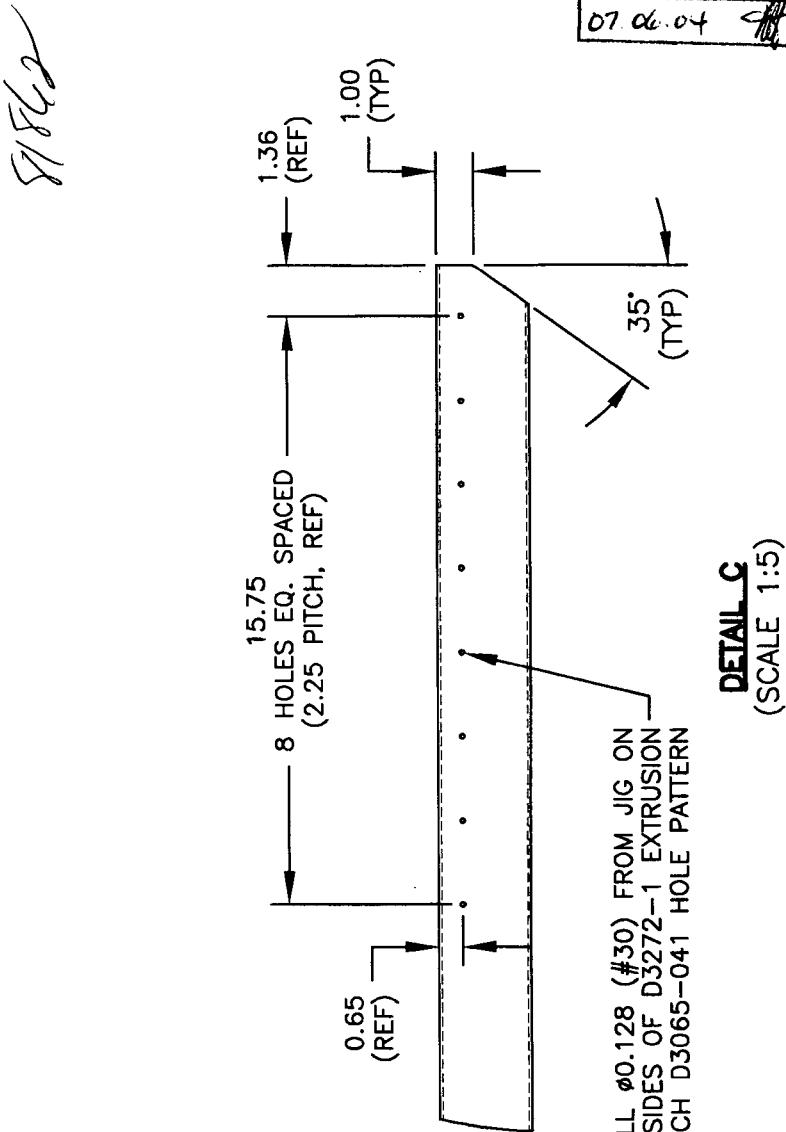
NOTE: Date & initial all entries

DART

DESIGN <i>QP</i>	DRAWN BY <i>AS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>AS</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20



D3272-1 STEP
(MAKE FROM D2622-120 STEP EXTRUSION)



DRILL #0.128 (#30) FROM JIG ON
BOTH SIDES OF D3272-1 EXTRUSION
TO MATCH D3065-041 HOLE PATTERN

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY

DART AEROSPACE LTD.

D350-591.

Page 23 of 23

Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	<i>Heli-Access-Step™</i> , Long Step – High Skid, LH
	X							D350-591-212	<i>Heli-Access-Step™</i> , Long Step – High Skid, RH
		X						D350-591-213	<i>Heli-Access-Step™</i> , Short Step – High Skid, LH
		X						D350-591-214	<i>Heli-Access-Step™</i> , Short Step – High Skid, RH
			X					D350-591-215	<i>Heli-Access-Step™</i> , Short Step – Low Skid, LH
				X				D350-591-216	<i>Heli-Access-Step™</i> , Short Step – Low Skid, RH
					X			D350-591-311	<i>Heli-Access-Step™</i> , Long Step – High Skid, LH
						X		D350-591-312	<i>Heli-Access-Step™</i> , Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
1								D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
	1							D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
		1						D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
			1					D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
				1				D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
					1			D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
						1		D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8					2	2	D2274	RADIUS BLOCK
							2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4					2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.

• COPYRIGHT © 1993 BY DART AEROSPACE LTD. •

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Revision: **G**
Date: 08.10.06